

split BLUE

Date: Friday, 20/02/2009 10:10:12 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 45294 -2  
Estimate Number : 10318  
P.O. Number :  
This Issue : 20/02/2009 S.O. No. :  
Prsht Rev. : NC  
First Issue : 27/01/2009 Type : PURCHASED PARTS  
Previous Run : 44217  
Written By :  
Checked & Approved By :  
Comment : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF

Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG  
Part Number : D2659  
Drawing Number : D2659 REV A  
Project Number : N/A  
Drawing Revision :  
Material :  
Due Date : 20/02/2009 Qty: 16 Um: Each

(12)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2657 Lug



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Lug B35662 x12 EL 9-2-20

2.0 D2658 Lug Assembly



\* Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Lug Assembly B45296 x12 EL 9-2-20

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8208  
A/R Steel Rod M108.350 x12 EL 9-2-20

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0 SPRAY PAINTING SPRAY PAINTING



Comment: -PRIME GREY  
-SPRAY PAINT DELFLEET BLUE  
-CLEAR DELFLEET

45 09-02-23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 45294

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC14

INSPECT SPRAY PAINT



*ml 09 02 24*



*(12)*

Comment: INSPECT SPRAY PAINT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*1/9/24 (12)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/24*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 09.02.24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

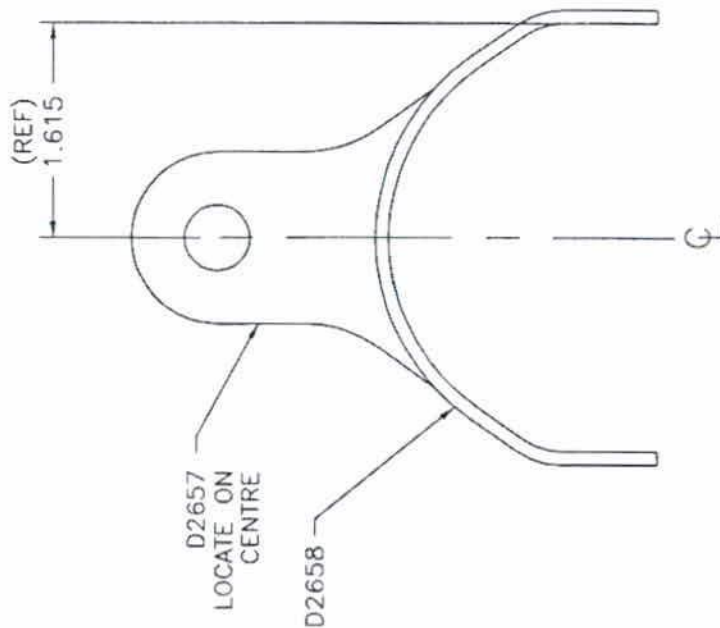
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



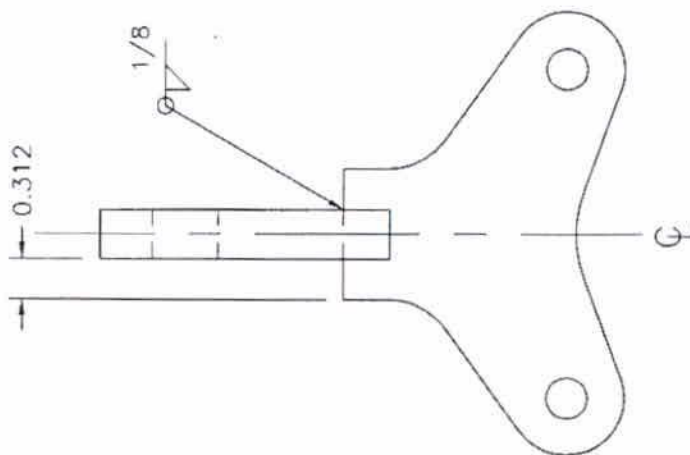
DESIGN <i>DB</i>	DRAWN BY <i>DB</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DB</i>	APPROVED <i>DB</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED  
97/11/06 DS



45294

D2659 LUG ASSEMBLY



WELD PER DART QSI 004  
FINISH: POWDER COAT PER DART QSI 005 4.4  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)